

ALL INFORMATION CONTAINED HEREIN IS UNCLASSIFIED

July-06-12 11:47:09 AM

Page 2

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop *NS2*

Item Name: 2.75 Support

Start Date: 7/20/12 **Start Qty:** 16.00

16

Cust Item ID:

Required Date: 7/20/12 **Req'd Qty:** 16.00

16

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:**Date:**

Stop

NR2

OC:

Date:

SPC (Y/N):

Date:

[illegible]

Work Order ID 86733

86733

Page 3

July-06-12 11:47:09 AM

Item ID: D2893-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 2.75 Support

Start Date: 7/20/12

Start Qty: 16.00

16

Cust Item ID:

Required Date: 7/20/12

Req'd Qty: 16.00

16

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 12/08/12

MF

12-08-23

Picklist Print

July-06-12 11:47:08 AM

Page 1

Work Order ID: 86733
 Parent Item: D2893-1
 Parent Item Name: 2.75 Support

Start Date: 7/20/12 Required Date: 7/20/12
 Start Qty: 16.00 Required Qty: 16.00

Comments: IPP: C02.11.26Reformat; Added P/OKJ
 IPP D 06.04.19 removed alodine EC
 IPP Rev:E Added priming as per Rev B 07-04-30 JLM
 IPP F 08.03.19 Re-format EC verified by: DD
 IPP Rev:G 08-05-15 add QC14 DD verified by:EC
 rev.C DD verf:EC
 IPP Rev:H 11.08.04 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078		Manufactured	No			100	Each	10.0000	0.5	8.4210526	8	12/08/07	

D2893-1 TURNING DETAIL

Location	Loc Qty	Loc Code
MAT	-10	
MAT060	20	
84787	10	
→ 88710		

8

DART AEROSPACE LTD		Work Order:	96733
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B C <i>DF8</i> 12/07/08	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.983	2.985	2.990	2.990	2.996
AB	0.440	0.460		.390	.440	.440	.445	.445
AC	0.125	0.160		.109	.134	.135	.136	.144
AD	0.040	0.060		.049	.050	.050	.050	.050
AE	0.188	0.193		.190	.190	.190	.190	.190
AF	0.125	0.160		.142	.138	.138	.140	.138
AG	0.140	0.160		.149	.149	.148	.148	.147
AH	1.360	1.400		1.366	1.368	1.3715	1.370	1.371
AI	0.040	0.060		.053	.0475	.052	.053	.053
AJ	1.190	1.230		1.2195	1.214	1.2165	1.217	1.215
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject				Scrap				

Measured by: *St/et* **Date:** 12/08/07

Audited by: *SL* **Date:** 12-08-14

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<i>St/et</i>

DART AEROSPACE LTD		Work Order: 86733
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: <i>B C</i> <i>12/07/08</i>	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	10
HAAS Section								
AA	2.985	3.005		2.997	2.999	2.999	2.994	3.000
AB	0.440	0.460		.442	.442	.442	.442	.442
AC	0.125	0.160		.138	.139	.141	.140	.142
AD	0.040	0.060		.056	.056	.057	.060	.050
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.140	.140	.140	.140	.142
AG	0.140	0.160		.146	.148	.147	.150	.147
AH	1.360	1.400		1.372	1.367	1.367	1.370	1.369
AI	0.040	0.060		.049	.051	.051	.049	.047
AJ	1.190	1.230		1.216	1.212	1.209	1.214	1.210
AK	0.010	0.020		.012	.012	.012	.012	.012
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.522	2.519	2.521	2.521	2.521
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.269	.269	.269	.269	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: *ET* Date: 12-08-09

Audited by: *L* Date: 12-08-11

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: <i>PL 733</i>
Description: Ø2.750 Support		Part Number: <i>D2893-1</i>
Inspection Dwg: D2893	Rev: <i>B C</i> <i>12/07/09</i>	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	2.985	3.005		2.996	2.996	2.996	2.996	2.994
AB	0.440	0.460		.441	.441	.441	.441	.441
AC	0.125	0.160		.141	.141	.144	.140	.139
AD	0.040	0.060		.049	.50	.50	.049	.049
AE	0.188	0.193		.189	.190	.189	.189	.189
AF	0.125	0.160		.140	.140	.144	.141	.142
AG	0.140	0.160		.143	.147	.150	.148	.151
AH	1.360	1.400		1.367	1.381	1.370	1.376	1.372
AI	0.040	0.060		.050	.049	.054	.049	.057
AJ	1.190	1.230		1.211	1.216	1.212	1.225	1.216
AK	0.010	0.020		.012	.012	.012	.012	.012
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.526	2.524	2.525	2.521	2.520
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: *RT* **Date:** *12-08-09*

Audited by: *SL* **Date:** *12-08-14*

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	86733
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: <i>BC</i> <i>DEF</i> <i>12/7/18</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16X	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.997				
AB	0.440	0.460		.441				
AC	0.125	0.160		.142				
AD	0.040	0.060		.047				
AE	0.188	0.193		.189				
AF	0.125	0.160		.141				
AG	0.140	0.160		.146				
AH	1.360	1.400		1.373				
AI	0.040	0.060		.046				
AJ	1.190	1.230		1.216				
AK	0.010	0.020		.012				
AL	0.053	0.073		.063				
AM	0.240	0.260		.250				
AN	2.518	2.538		2.520				
AO	84.39	90.39		87.39				
AP	0.261	0.266		.261				
AQ	0.053	0.073		.063				
AR								
AS								
AT								
Accept/Reject								

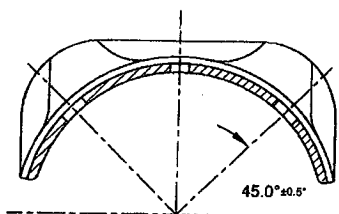
Measured by: *PT* Date: 12-08-10

Audited by: *SL* Date: 12-08-14

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<i>JA</i>

WORK ORDER
NO. R0.063 86733
TYP



CONDITION

CL SYM

R0.500 TYP

2.995

1.250

0.450

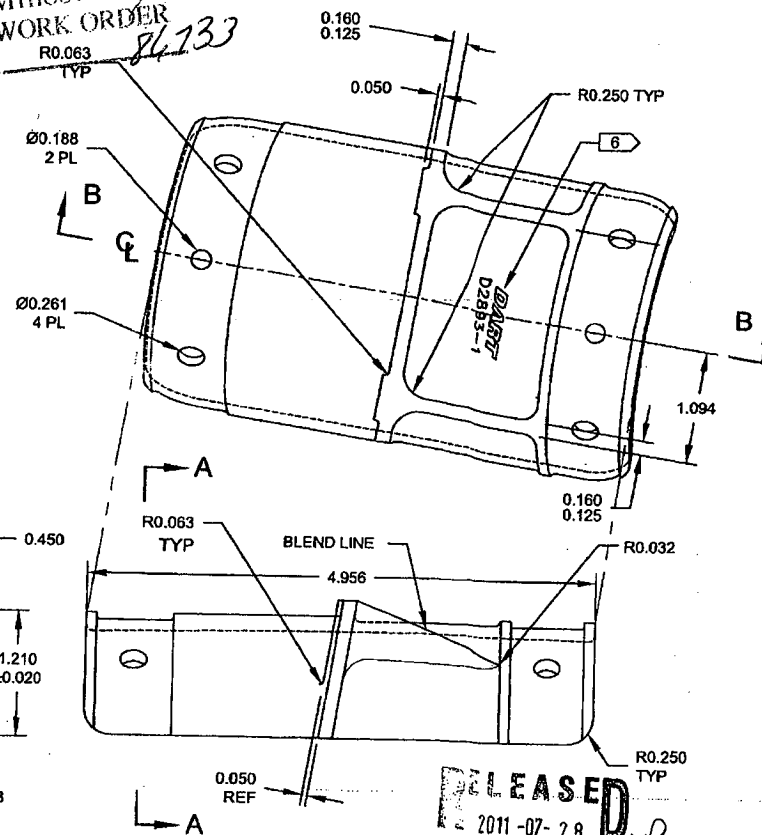
R1.387^{+0.005}_{-0.000}

R0.750

1.380 ± 0.020

1.210 ± 0.020

R0.083 REF



1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF DART SPEC. D6104)

3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ± 0.010) UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP, PER DART QSI 044 6.3:

7) WEIGHT: 0.78 lb

8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK
(OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A
ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

D2893-1 SUPPORT

RELEASED
2011-07-28

C	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION	CP	11.07.15
B	UPDATE DIMS AS MFG, PRIME INSIDE	PH	07.03.16
A	NEW ISSUE	CP	01.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>Q</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>Q</i>		
CHECKED	<i>ASS</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. C
DE APPR.	<i>[Signature]</i>	D2893	SHEET 1 OF 1
DATE	11.07.15	TITLE	SCALE
		Ø2.750 SUPPORT	NTS
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